



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

D4357-041
Job Sheet 177441



Part No: D4357-041

Job Qty: 4 ea

Part Name: Step, LH Crew



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/11/18

Job Tracking No:

Due Date: 5/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 12-01-10 JLM VERIFIED BY:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		5/31/18	0.00	0.00	Start Up Large Fab-4		D.M.L 18-5-14
100	Large Fab	4 pcs		5/31/18	0.00	1.90	Large Fab 8		D.M.L 18-5-14
110	QC	4 pcs		5/31/18	0.00	0.00	QC5		CPL
120	Large Fab	4 pcs		5/31/18	0.00	1.90	Large Fab 2		CPL
130	QC	4 pcs		5/31/18	0.00	0.00	QC9		PD 18-05-16
140	QC	4 pcs		5/31/18	0.00	0.00	QC5		PD 18-05-16
150	HandFinish	4 pcs		5/31/18	0.00	0.97	HandFinish1		CPL
160	QC	4 pcs		5/31/18	0.00	0.00	QC3		CPL
170	Large Fab	4 pcs		5/31/18	0.00	1.90	Large Fab 2		CPL 18-5-29
180	QC	4 pcs		5/31/18	0.00	0.00	QC10		38 DA6
190	QC	4 pcs		5/31/18	0.00	0.00	QC5		9-89 38
200	HandFinish	4 pcs		5/31/18	0.00	0.97	HandFinish1		SLA 18-05-31
210	Powdercoat	4 pcs		5/31/18	0.00	0.69	Powdercoat1		BL 18-5-31
211	QC	4 pcs		5/31/18	0.00	0.00	QC3		18-5-31
215	HandFinish	4 pcs		5/31/18	0.00	0.97	HandFinish3		18-5-31
220	QC	4 pcs		5/31/18	0.00	0.00	QC3		18-5-31
230	Packaging	4 pcs		5/31/18	0.00	0.00	Packaging3-2		18-5-31
240	QC21-SA	4 Ea		5/31/18	0.00	0.00	QC21		18-5-31

Part Op 100 - 1-Cut D4357-1 using D2622 extrusion as per Dwg D4357 2-Drill, c'sink one hole on top of step as per dwg 3-Debur
Descriptions: and bevel ends for welding

120 - 1-Weld end cap (ONE END ONLY) 2-Grind end cap welds flush 3-weld lugs as per Dwg D4357

170 - 1-Inspect for foreign object per QSI 024 2-Weld Remaining end cap as per Dwg D4357 3-Grind end cap weld flush as per dwg D4357 4- install rivet as per dwg

210 - START TIME: 12:50 OVEN TEMPERATURE: 320° FINISH TIME: 1:20 M188839

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	.2400 Ea (.06 ea)	90-Start up Operation	5046116
D2734	Step End Plate	8 Ea (2 ea)	90-Start up Operation	5063695
D3461-1	Mounting Plate	4 Ea (1 ea)	90-Start up Operation	1X587563072100
D3461-3	Mounting Plate	4 Ea (1 ea)	90-Start up Operation	5072102
MS20601-AD4W2	Rivet	4 Ea (1 ea)	170-Large Fab	

M.U. 003199

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	0	157	0
	D2734	8	40	0
	D3461-1	4	5	0
	D3461-3	4	1	0
170-Large Fab	MS20601-AD4W2	4	125	0

Part Specifications

Specifications could not be found.

Plex 5/11/18 9:27 AM Dart.lajeunesse.marie



Container No: S073926



Part: D4357 - 041

Job No: 177441

Serial No/Batch: S073926

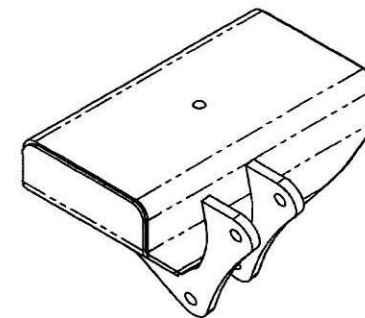
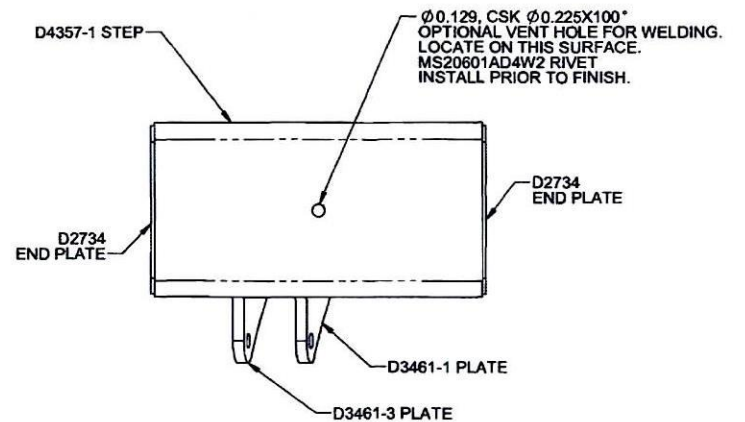
Revision: A

Inspector:

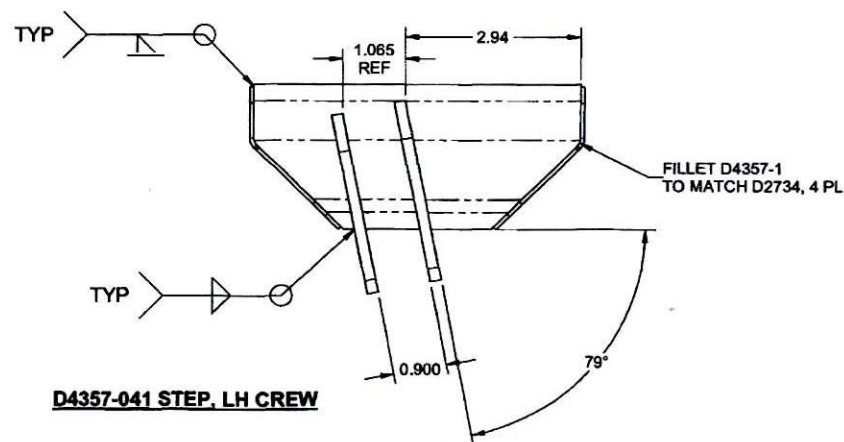
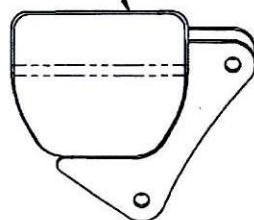
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Date: 05/24/18

ITEM	QTY	P/N	DESCRIPTION
1	X	D4357-041	STEP, LH CREW
2	1	D4357-1	STEP
3	2	D2734	END PLATE
4	1	D3461-1	PLATE
5	1	D3461-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)



2 APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



RELEASED
2011-05-26

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.6 (REMOVABLE TAG)
- 7) WEIGHT: 0.47 lbs
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE	CP	10.12.17
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.17		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4357** REV. A
SHEET 1 OF 3
TITLE **STEP, CREW** SCALE NTS

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